

Work Order ID 143665

143665

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March 18, 2016 10:19:13 AM

Item ID: D350-567-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Exterior Super-sized Window

Start Date: 3/21/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/23/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: SH Date: **20160318** Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-567	E

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-567-113		CHG003						

DAS
6
9-89

MCS 16-03-21

Shob
16/3/22

110	Packaging	0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								

IX
MAR 21 2016

DAS
6
9-89
DAS
28
9-89

120	QC4- 100% Inspect kits for completeness	0.00							
120	QC								
QC	Memo	0.00							
Quality Control									

Shob
16/3/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D350-567-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Exterior Super-sized Window
 Start Date: 3/21/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/23/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130						DAS			
Packaging	Memo	0.00				27			
Packaging	Identify and pack for shipping as per PPPD350-567-113 Location:FG032					9-89			
						MAR 22 2016			
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									
						MLJ			MAR 22 2016
						MLJ			MAR 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER :							

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143665

D350-567-113

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:A 04-08-24 New Issue JLM

IPP Rev:B 08-10-07 as per revD DD verified by:

IPP REV:C

13.10.15 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8439 *DT8439* TEMPLATE		Manufactured	No				Each	0.0000	1	1			DAS 28 9-89
D2463 *D2463* 1/2" Seal (\$Per Foot)		Manufactured	No			110	f	510.7459	7.166	7.543158			DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				DAS 28 9-89
				ST409			500						
				140013			500						
				ST638			10.74591044						
				125469			10.7459104						
1x (D2463-0860 as per dwg) CUT TO 86.00"													
D3290-041 *D3290-041* Replacement Exterior Window For -111		Manufactured	No			110	Each	4.0000	1	1			DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				DAS 28 9-89
				ST433			4						
				130869			2						
				136402			2						

Picklist Print

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Work Order ID: 143665

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Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

2600-6

Purchased No

110 Each

148.0000

2600-6

Camlock Stud

12 24
12 24

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST569

48

M133064

48

ST578

50

M133483

50

ST580

50

M133932

50

2600-LW

Purchased No

110 Each

250.0000

2600-LW

Washer, Camlock Retaining

12 24
12 24

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST569

100

m131959

100

ST580

150

m134370

150

212-12

Purchased No

110 Each

140.0000

212-12

Receptacles

12 24
12 24

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST568

40

M133064

2

M133363

38

ST577

100

M133932

50

M134370

50

MAR 21 2016

Picklist Print

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Work Order ID: 143665

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Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

AN526C832R9

Purchased

No

110

Each

520.0000

21
**

2142

AN526C832R9

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

over006

325

M134063

125

M134376

200

ST327

195

M132823

45 73

M133932

150

110

Each

1,997.000

42
**

4284

NAS1149DN832J

Purchased

No

NAS1149DN832J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST260a

1500

M134180

1500

ST263

413

M131697

413

84

MAR 21 2016

DAS
27
9-89

DAS
28
9-89

Picklist Print

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Work Order ID: 143665

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Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

1,469.000

****21**

2142

MS21042L08

Nut

DAS

8

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

580

m133134

3

m134063

577

ST303

388

m133922

388

ST308

400

m134376

400

2/2

MS20426AD3-5

Purchased

No

110

Each

4,793.000

****24**

2424

MS20426AD3-5

Rivet

DAS

8

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

4144

4533

4144

ST312

649

4444

649

FG-778150-550-ROL

Purchased

No

110

sf

545.1463

****18**

2448

FG-778150-550-ROL

7781 9oz Glass 50x125yd

DAS

8

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

CA2

545.1463415

M127701

545.146342

18

2sq yards

MAR 21 2016

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Shop Packet Print

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REFERENCE ONLY

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		{ 1 }			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		{ 1 }			D2463-0880	NEOPRENE SEAL
	9	{ 12 }			2600-6	1/4 TURN FASTENER
	9	{ 12 }			2600-LW	WASHER
	9	{ 12 }			212-12	RECEPTACLE
	22	{ 21 }			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	{ 42 }			AN960JD8	WASHER
	22	{ 21 }			MS21042L08	NUT (OR MS21042-08)
	18	{ 24 }			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	{ 2 SQ. YD }			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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